

Date: Thursday, 11/09/2008 10:43:12 AM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : DRIVE SHAFT TUNNEL
 Job Number : 41982-2
 Estimate Number : 13044
 P.O. Number :
 This Issue : 11/09/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : 11 Type : SMALL /MED FAB
 Previous Run : 39926
 Part Number : D3648041
 Drawing Number : D3648 REV.B
 Project Number : N/A
 Drawing Revision : B
 Material :
 Due Date : 10/10/2008 Qty: 5 Um: Each
 Written By :
 Checked & Approved By : JLD 08-9-11
 Comment : Est Rev:A New Issue 07-10-03 EC verified by: DD
 Est Rev:B Ecn 1113P 08-01-22 DD verified by: EC
 Est Rev:C ECN1162 08-04-02 DD verified by: EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
 Pick Packing Kit

2.0 D3649041 Tunnel Bottom Panel Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 TUNNEL ASSEMBLY, BOTTOM PANEL
 batch: B42038

FF 08/10/03

(1)

3.0 D3650041 Tunnel Top Panel Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 WELDMENT ASSEMBLY, TOP PANEL
 batch: B42039

FF 08/10/03

(1)

4.0 D3651041 Aft Base Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 AFT BASE ASSEMBLY
 batch: B42040

FF 08/10/03

(1)

5.0 AN3C3A Bolt



Comment: Qty.: 40.0000 Each(s)/Unit Total : 40.0000 Each(s)
 Bolt
 batch: M109297

FF 08/10/03

1

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DRIVE SHAFT TUNNEL

Job Number: 41982

Part Number: D3648041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

AN960C10

WASHER



Comment: Qty.: 40.0000 EACH(s)/Unit Total : 40.0000 EACH(s)

WASHER

batch: M109148

FF 08/10/03 (1)

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Assemble as per dwg D3648

2- Seal mating surface and all gaps as per dwg D3648 with

Proseal 700 fire wall sealant

batch: M109415

FF 08/10/03 (1)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Soslo/03 @

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart part # using a fine point permanent marker and Stock

Location: PPP 41936

FF 8/10/03 (1)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



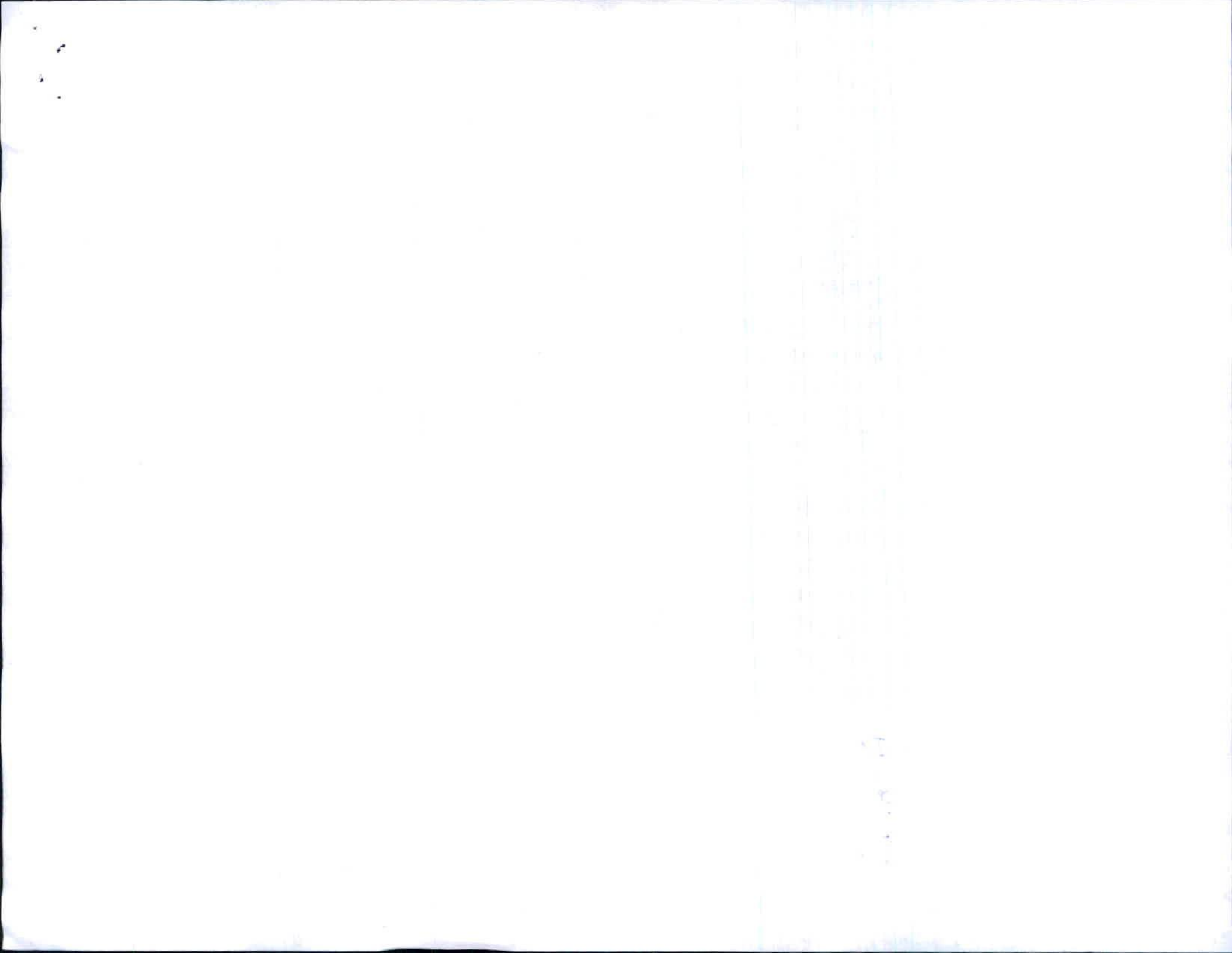
Comment: FINAL INSPECTION/W/O RELEASE

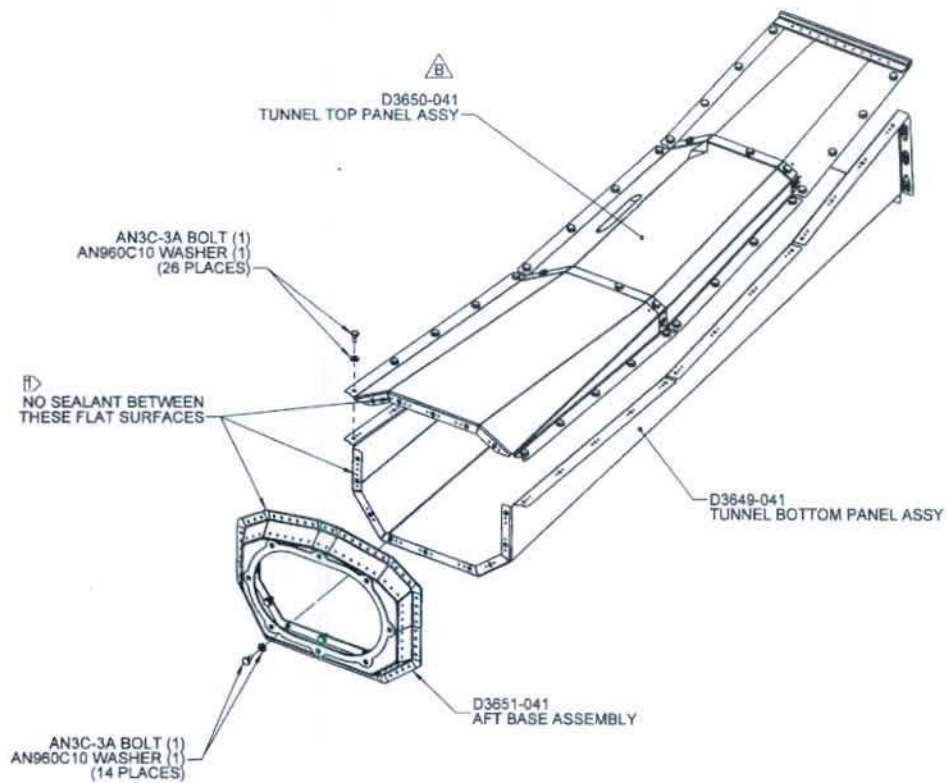
FF 08/10/03 (1)

Job Completion



U 08/10/03





D3648-041 DRIVE SHAFT TUNNEL ASSEMBLY

NOTES:

- 1) SEAL MATING SURFACES AND ALL GAPS USING PROSEAL 700 FIRE WALL SEALANT EXCEPT WHERE NOTED.
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N D3648-041 USING FINE POINT PERMANENT INK MARKER
- 7) TORQUE FASTENERS TO 15-25 in-lb
- 8) WEIGHT: 9.2 lbs

PART LIST

QTY -041	PART NUMBER	DESCRIPTION
X	D3648-041	DRIVE SHAFT TUNNEL ASSEMBLY
1	D3649-041	TUNNEL BOTTOM PANEL ASSEMBLY
1	D3650-041	TUNNEL TOP PANEL ASSEMBLY
1	D3651-041	AFT BASE ASSEMBLY
40	AN3C-3A	BOLT
40	AN960C10	WASHER

RELEASED
07.03.27/100

B	UPDATE WITH REVISED D3650-041	RF	08.01.07
A	NEW ISSUE	RF	07.11.07
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED	IE		
MFG. APPR.	M.P.		
APPROVED			
DE APPR.			
DATE	08.01.07		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3648** REV. B
SHEET 1 OF 1
SCALE 1:5
TITLE **DRIVE SHAFT TUNNEL ASSY**

COPYRIGHT © 2007 BY DART AEROSPACE LTD
THIS DOCUMENT IS PROPERTY OF DART AEROSPACE LTD AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR FOR THE REPRODUCTION OF ANY PART THEREOF WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 4787

